

Work Order ID 51112

August 4, 2009 11:04:23 AM



Page 1

Item ID: D3518-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Strut Assembly

Start Date: 8/14/09 Start Qty: 4.00



Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *mf* Date: *09-08-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr Revision Nbr

D3518 Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3518

SB 09/08/17

(5)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

=> 8/02/08/17

(4)

120

0.00



Identify as per dwg & Stock Location *271*

Packaging

Memo

0.00

Packaging

9/8/17

(5) &

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 51112

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Page 2

Item ID: D3518-041
Revision ID: B
Item Name: Strut Assembly

Accept



Setup Start



Stop



Start Date: 8/14/09 Start Qty: 4.00
Required Date: 8/21/09 Req'd Qty: 4.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/18 JF
MF 09-08-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

August 4, 2009 11:04:22 AM

Page 1

Work Order ID: 51112

Parent Item: D3518-041RevB

Parent Item Name: Strut Assembly

Comments:

Start Date: 8/14/09

Required Date: 8/21/09

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

AN3-13A Purchased No

100

Each

100.0000

8.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

100

104746

100

AN316C6R Purchased No

100

Each

101.0000

4.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

101

102809

1

108038

100

19

SB 09/08/17

5

SB 09/08/17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51112

Parent Item: D3518-041RevB

Parent Item Name: Strut Assembly

Comments:

Start Date: 8/14/09

Required Date: 8/21/09

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960JD10 | | Purchased | No | | | 100 | Each | 1,827.000 | 16.0000 | | | |



Washer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1827

105442

95

109059

2

109840

23

110985

202

111279

13

111668

492

112314

1000

D2324-5RevC

Manufactured

No

100

Each

45.0000

8.0000



Strap

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

45

46324

1

47563

44

D3518-1RevB

Manufactured

No

100

Each

0.0000

4.0000



Strut

851 loc

5

8/09/07/17 ⑤

8/09/08/17

August 4, 2009 11:04:22 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 51112

Parent Item: D3518-041RevB

Parent Item Name: Strut Assembly

Comments:

Start Date: 8/14/09

Required Date: 8/21/09

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D3518-3RevB

Manufactured

No

100

Each

3.0000

4.0000



Stainless Steel Ball Joint Rod End

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

B 51 108

48211

3

2
3

SB 09/08/17 ⑤

MS21042L3

Purchased

No

100

Each

3,517.000

8.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3517

110844

32

111274

493

111668

992

112314

2000

10

SB 09/08/17 ⑤

August 4, 2009 11:04:23 AM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

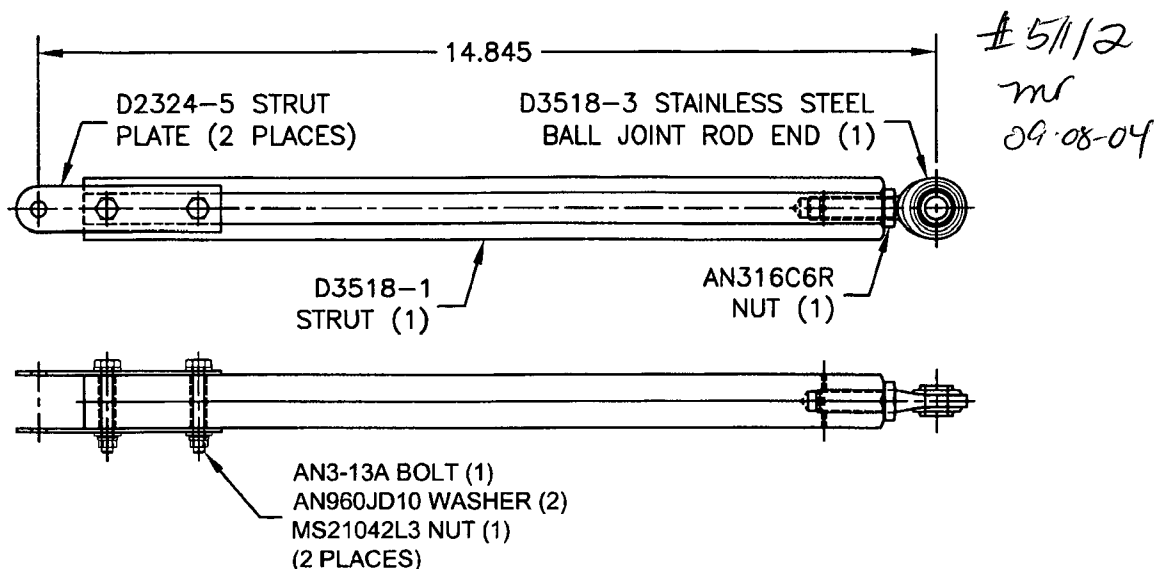
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3518 | REV. B SHEET 1 OF 3 |
| DATE 06.10.23 | | TITLE BASKET (A119) STRUT | SCALE 1:3 |
| A | 06.06.21 | NEW ISSUE | |
| B | 06.10.23 | RE-DESIGN | |



D3518-041 STRUT ASSEMBLY

| QTY -041 | Part Number | Description |
|-------------|-------------|------------------------------------|
| X | D3518-041 | STRUT ASSEMBLY |
| 2 | D2324-5 | STRUT PLATE |
| 1 | D3518-1 | STRUT |
| 1 | D3518-3 | STAINLESS STEEL BALL JOINT ROD END |
| 2 | AN3-13A | BOLT |
| 1 | AN316C6R | NUT |
| 4 | AN960JD10 | WASHER |
| 2 | MS21042L3 | NUT |

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

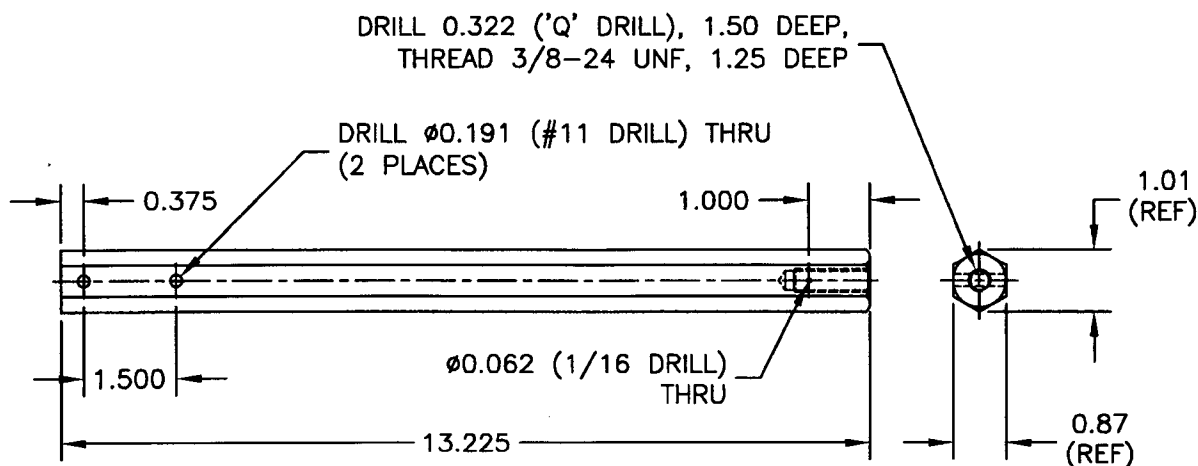
RELEASED
06.11.17 *[Signature]*

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DART

| | | | |
|----------------------|----------------------|---|------------------------|
| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>H</i> | DRAWING NO. D3518 | REV. B SHEET 2 OF 3 |
| DATE 06.10.23 | | TITLE BASKET (A119) STRUT | SCALE 1:3 |

**D3518-1 STRUT***51112***NOTES:**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

RELEASED

06-11-17 *H*

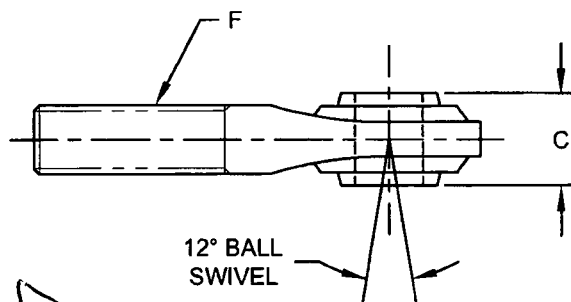
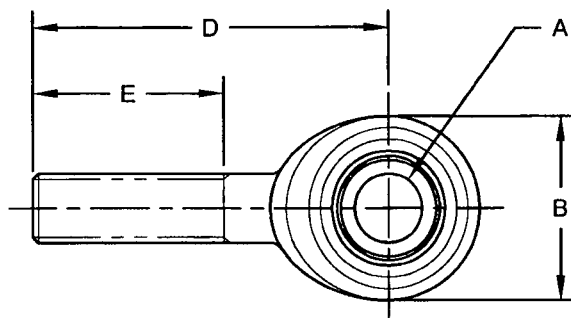
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|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3518 | REV. B SHEET 3 OF 3 |
| DATE 06.10.23 | | TITLE BASKET (A119) STRUT | SCALE 1:1 |

SPECIFICATION CONTROL DRAWING



| DART P/N | A | B | C | D | E | F | LOAD* | POSSIBLE SUPPLIER |
|----------|-------|------|------|-------|------|-------------------|-------|-------------------------------|
| D3518-3 | 0.375 | 1.00 | 0.50 | 1.938 | 1.25 | 3/8-24 UNF, RH | 4012 | McMASTER-CARR, P/N 2458K14 |

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.11.17 *[Signature]*

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